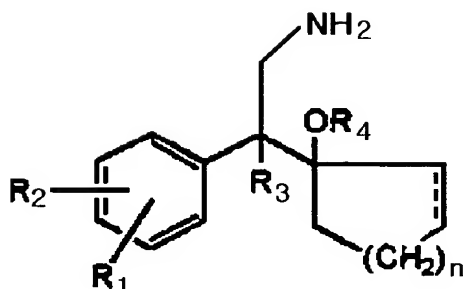


In the claims:

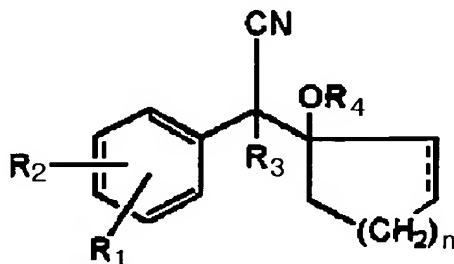
Claim 1 (Currently amended)

A process for the preparation of a compound of formula I,



(I)

wherein  $R_1$  and  $R_2$  are ortho or para substituents, independently selected from the group consisting of hydrogen, hydroxyl,  $C_1$ - $C_6$  alkyl,  $C_1$ - $C_6$  alkoxy,  $C_7$ - $C_9$  aralkoxy,  $C_2$ - $C_7$  alkanoyloxy,  $C_1$ - $C_6$  alkylmercapto, halo and trifluoromethyl;  $R_3$  is hydrogen or  $C_1$ - $C_6$  alkyl;  $R_4$  is hydrogen,  $C_1$ - $C_6$  alkyl, formyl or  $C_2$ - $C_7$  alkanoyl;  $n$  is one of the integers 0, 1, 2, 3 or 4; and the dotted line represents optional olefinic unsaturation; comprising, hydrogenating a compound of formula III,



(III)

in the presence of an alkaline nickel or cobalt catalyst and from about 0.5 to about 1.5 equivalent of the compound of formula III of ammonia solution, at a temperature of about  $10^\circ C$  to about  $20^\circ C$ .

Claim 2 (Original) The process of claim 1 wherein the catalyst is Raney-Ni.

Claims 3 – 4 (Cancelled)

Claim 5 (Original) The process of Claim 1 wherein hydrogenation is carried out in the presence of methanol, ethanol or isopropyl alcohol.

Claim 6 (Original) The process of Claim 1 wherein the amount of catalyst is from about 10 to about 50% by weight based on the amount of the compound of formula III.

Claim 7 (Original) The process of Claim 6 wherein the amount of catalyst is from about 30 to about 50% by weight based on the amount of the compound of formula III.

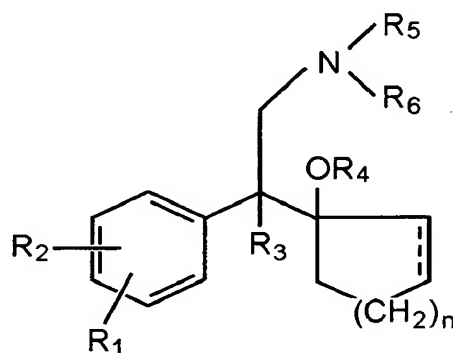
Claim 8 (Original) The process of Claim 1 wherein  $R_1$  is hydrogen, hydroxyl,  $C_1$ - $C_3$  alkoxy, chloro, bromo, trifluoromethyl or  $C_1$ - $C_3$  alkyl;  $R_2$  is  $C_1$ - $C_3$  alkyl,  $C_1$ - $C_3$  alkoxy, chloro, bromo, trifluoromethyl or  $C_2$ - $C_3$  alkanoyloxy;  $R_3$  is hydrogen or  $C_1$ - $C_6$  alkyl; and  $R_4$  is hydrogen.

Claim 9 (Cancelled)

Claim 10 (Original) The process of Claim 1 wherein the compound of Formula I is 1-[2-amino-1-(4-methoxyphenyl)ethyl]cyclohexanol.

Claim 11 (Original) The process of Claim 1 wherein the compound of Formula I is 1-[2-amino-1-(4-hydroxyphenyl)ethyl]cyclohexanol.

Claim 12 (Original) The process of Claim 1 further comprising alkylating the compound of formula (I) to provide compound of Formula (II)



wherein  $R_1$  and  $R_2$  are ortho or para substituents, independently selected from the group consisting of hydrogen, hydroxyl,  $C_1$ - $C_6$  alkyl,  $C_1$ - $C_6$  alkoxy,  $C_7$ - $C_9$  aralkoxy,  $C_2$ - $C_7$

alkanoyloxy, C<sub>1</sub>-C<sub>6</sub> alkylmercapto, halo and trifluoromethyl; R<sub>3</sub> is hydrogen or C<sub>1</sub>-C<sub>6</sub> alkyl ; R<sub>4</sub> is hydrogen, C<sub>1</sub>-C<sub>6</sub> alkyl, formyl or C<sub>2</sub>-C<sub>7</sub> alkanoyl; R<sub>5</sub> is hydrogen or C<sub>1</sub>-C<sub>6</sub> alkyl; R<sub>6</sub> is C<sub>1</sub>-C<sub>6</sub> alkyl; n is one of the integers 0, 1, 2, 3 or 4; and the dotted line represents optional olefinic unsaturation.

Claim 13 (Original) The process of Claim 12, further comprising conversion of the compound of formula (II) to a pharmaceutically acceptable salt.

Claim 14 (Original) The process according to Claim 13, wherein the compound of formula II is venlafaxine, O-desmethylvenlafaxine, N-desmethylvenlafaxine, N,N-didesmethylvenlafaxine, N,O-didesmethylvenlafaxine or O-desmethyl-N,N-didesmethylvenlafaxine, or a pharmaceutically acceptable salt thereof.

Claims 15 – 19 (Cancelled)